

Date: Thursday, 11/29/2007 11:06:55 AM
 User: Kim Johnston

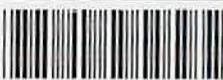
Process Sheet

SPL + 6
08/01/02

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 36040 - 2		
Estimate Number	: 12712		
P.O. Number	: N/A	Part Number	: D35371
This Issue	: 11/29/2007	Drawing Number	: D3537 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C
Previous Run	: 35696	Material	: N/A
Written By	:	Due Date	: 12/10/2007
Checked & Approved By	:	Qty:	100
Comment	: Est Rev:A New Issue 07-02-14 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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8.5104



Comment: Qty.: 0.0788 sf(s)/Unit Total : 7.8750 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: 105997 1B 07-12-6

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: C

1B 07-12-6

Prog Rev: C

108

2-Deburr if necessary

1B 07-12-6

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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1B 07-12-6

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

C 7/12/06 (+108)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

C 07/12/11 (

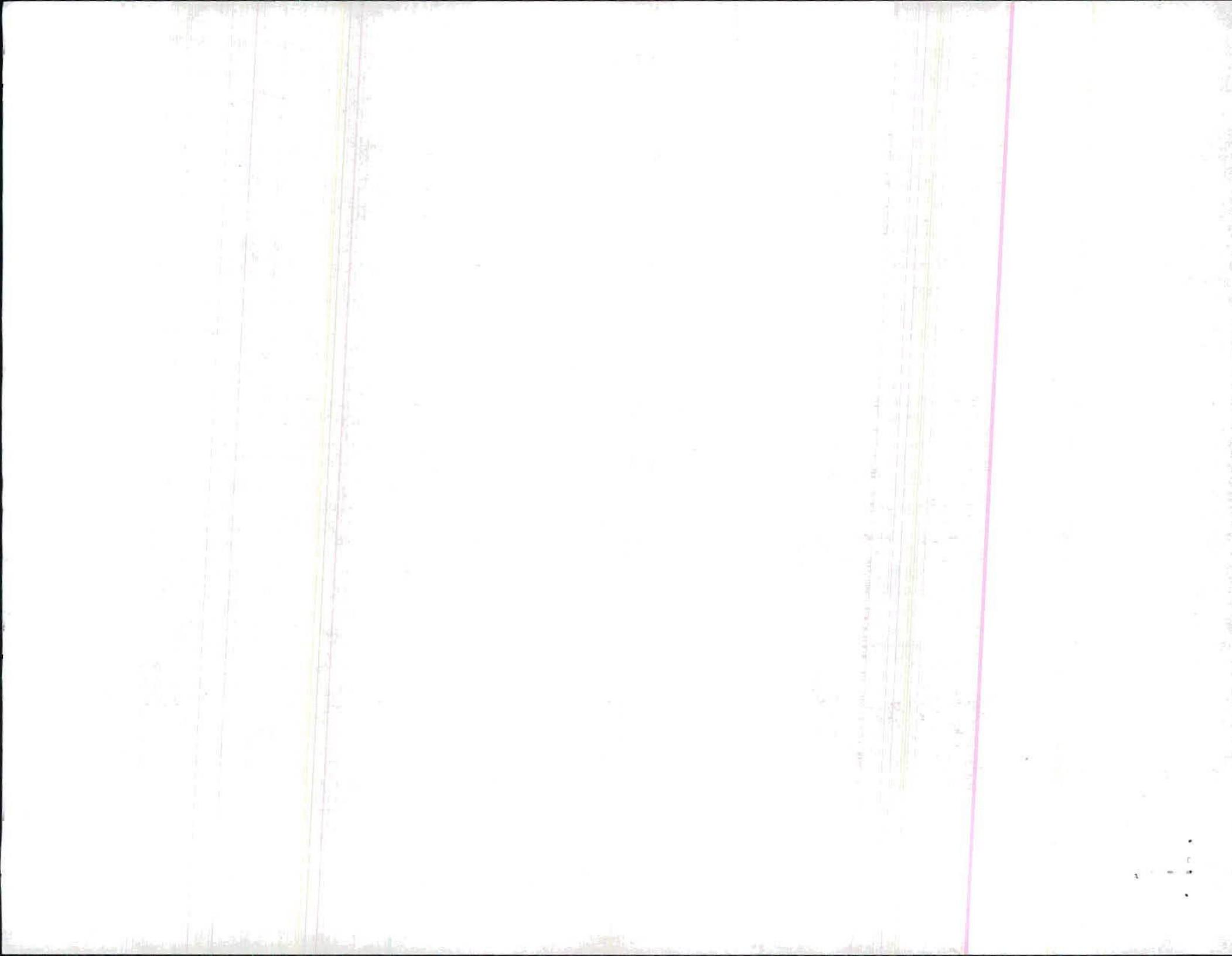
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/01/02	#9.0	w/o was split for 38 pcs		08/01/02	x38		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/01/02	#9.0	6 parts have a dim. of 3.600 instead of 3.625 per water jet cut no. 3m21.	PT 07-12-05 per QSF042	Parts are acceptable this is fine only. Acceptable edge distance remains based on E/D=1.5	PT 07-17-05 per QSF042	✓ 07/12/02	PT 07-12-05 per QSF042	✓ 07/12/02

NOTE: Date & initial all entries



Date: Thursday, 11/29/2007 11:06:55 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 36040

Part Number: D35371

Job Number:



Seq. #: Machine Or Operation:

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat M106390 / M105959

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

8/10/01/02 (38)

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10/01/02

(38)

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/01/02

(38)

9.0 POWDER COATING

POWDER COATING



M105642

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Fx 08/01/02 (38)

10.0 QC3

INSPECT POWDER COAT/ CHEMICAL CONVERSION



4J

Comment: INSPECT POWDER COAT/ CHEMICAL CONVERSION

08-01-02

(38)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-20

H5

08-01-02

(38)

12.0 QC21

FINAL INSPECTION/W/O RELEASE



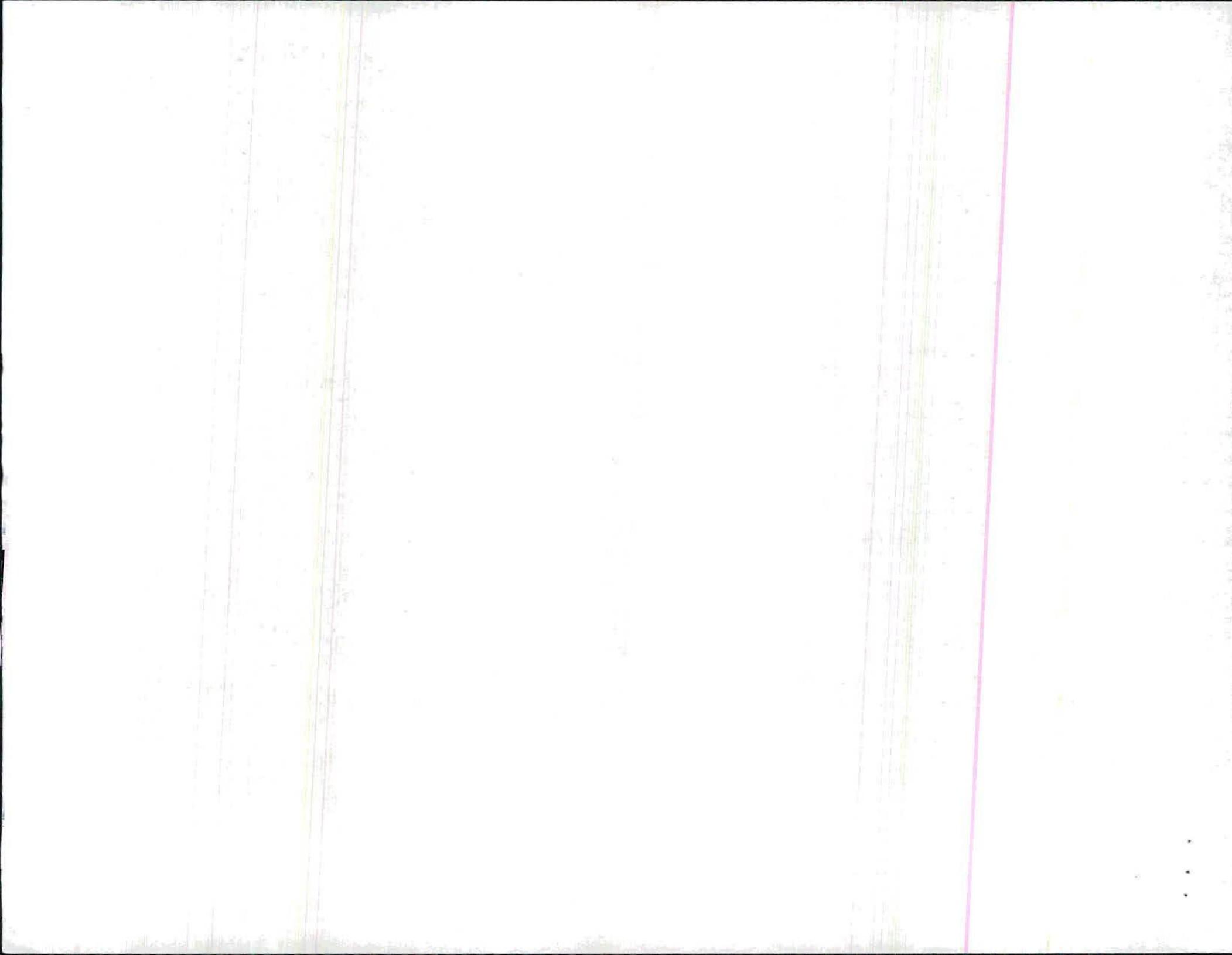
Comment: FINAL INSPECTION/W/O RELEASE

10/01/03

Job Completion



2008/1/2
W



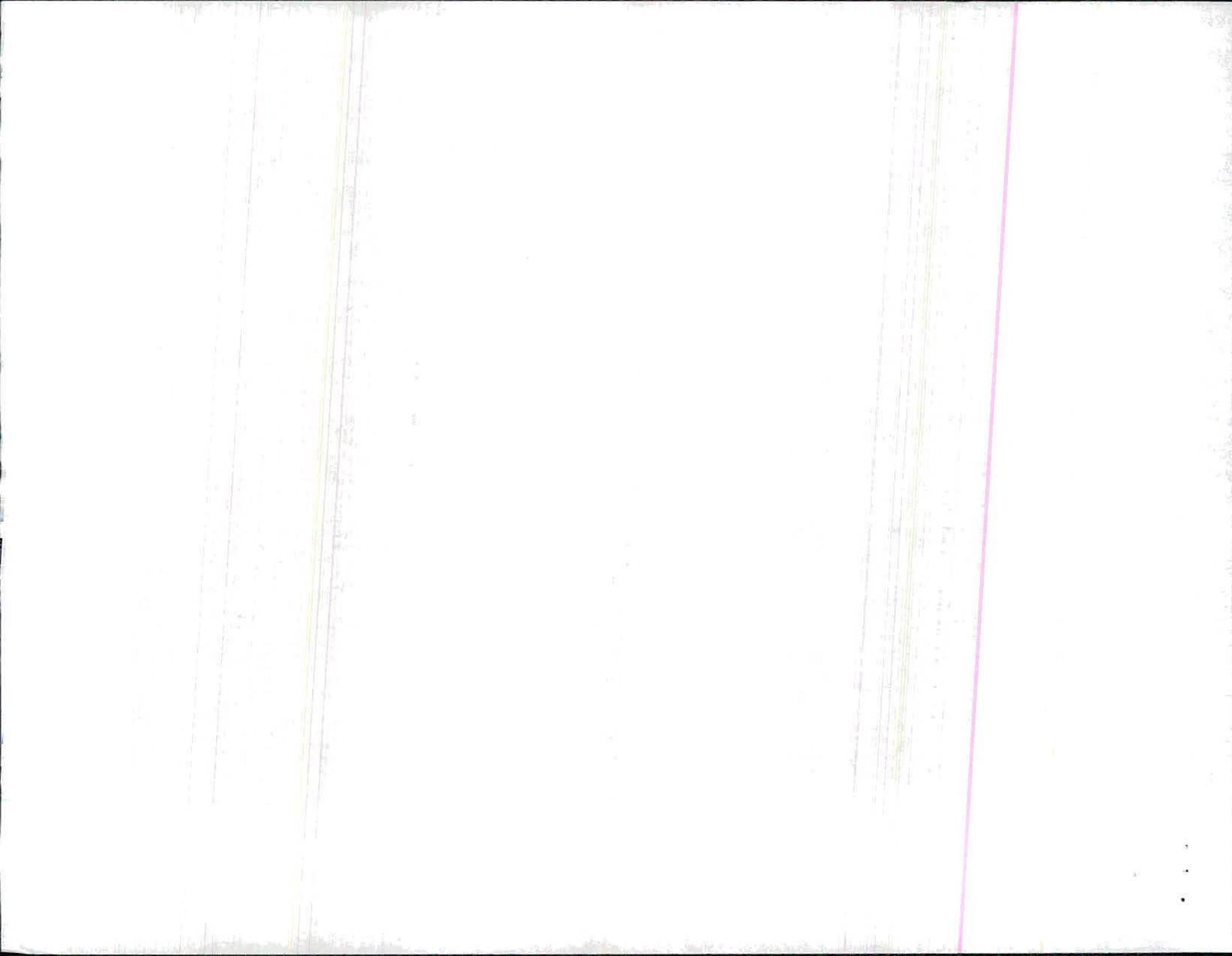
DART AEROSPACE LTD	Work Order:	36040
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

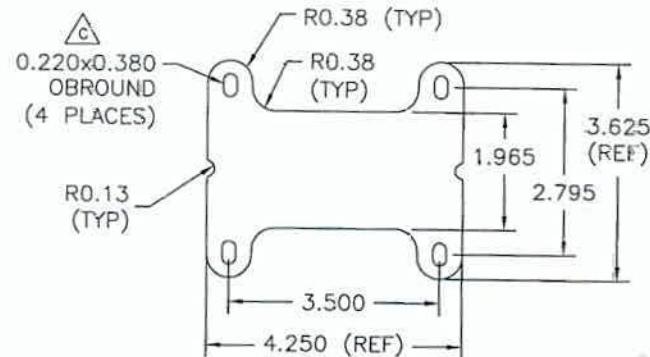
X First Article Prototype

Measured by:	<u>DB</u>	Audited by:	<u>C</u>	Prototype Approval:	N/A
Date:	<u>07-17-16</u>	Date:	<u>7/17/16</u>	Date:	N/A

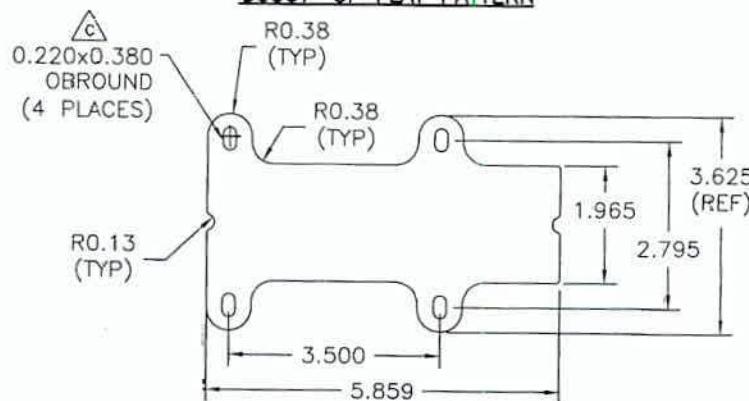
Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	JL



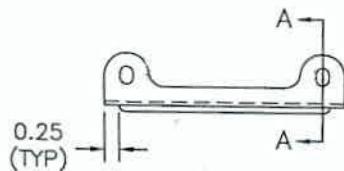
D3537-1F FLAT PATTERN



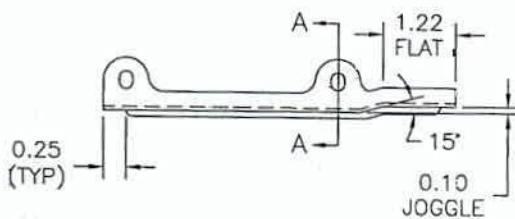
D3537-3F FLAT PATTERN



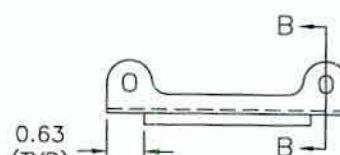
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



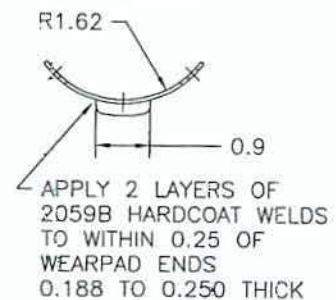
D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



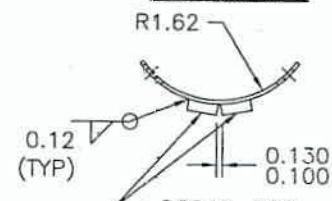
D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
 - 2) BREAK ALL SHARP CORNERS 0.063 MAX
 - 3) WELD PER QSI 004
 - 4) FINISH: POWDER COAT GREY SANDTEX (4.3/5.6) PER QSI 005 4.3
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A



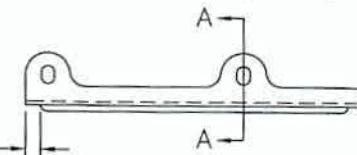
SECTION B-B



— D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES **REI**

RELEASED
07.05.08 AM

D3537-7 LONGITUDINAL BEAM
(MADE FROM D3537-3F)



C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN <i>CB</i>	DRAWN BY <i>PH</i>	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3537
		REV. C
DATE 07.04.13		TITLE WEARPAD
		SCALE 1:2
SHEET 1 OF 1		

SHOP CO
RETURN TO
ENGINEERING
CONTROLL
JECT TO AN
WITHOUT N
WORK O
NO. 36c

